

31.75

Dart Aerospace Ltd.

Date: Thursday, 19/03/2009 4:30:49 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 46614 -1  
 Estimate Number : 11119  
 P.O. Number :  
 This Issue : 19/03/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : MACHINED PARTS  
 Previous Run : 42946  
 Written By :  
 Checked & Approved By : JW 09.03.19  
 Comment : Est:A 01.07.11 New Issue SM  
 est B 07.04.09 rev.c dwg EC

Drawing Name : CLAMP  
 Part Number : D30411  
 Drawing Number : D3041 REV.C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 06/04/2009

Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



4.57 f(s)



Comment: Qty: 114 Total: 3.4986 f(s)

Lug Extrusion  
(D2423)

Batch: B45800

SA 09/03/24

4.57 f(s)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

SA 09/03/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



NCR →

Comment: HAAS CNC VERTICAL MACHINING #1  
Machine per folio FA153

SA 09/03/27

N.A 09/03/28

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 09/03/28

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 09/03/31



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 46614

Part Number: D30411

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

FL 09/03/31

(40)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counter  
S 09/03/31

(x40)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
Mask inside of 0.8120" diameter hole

m 110939

START TIME: 7:20  
OVEN TEMPERATURE: 320°  
FINISH TIME: 7:50

FL 09/04/09

(40)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11

09-04-13

(x40)

10.0 D2611 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	B46841

FF 09-04-14

(27)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Press D2611 bearing into lug as per Dwg D3041 with DT 9472
- 2- Stake bearing into place as per Dwg D3041 with DT 9456

R  
09.04.13

\*\*PLEASE SEE JASON BEFORE PRESSING  
BEARINGS FOR NEW TOOLING\*\*

201415

FF 09-04-14

(27)





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 46614

Part Number: D30411

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counter*  
*S 09/04/15* *(27)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ST 463*

*SS 09/04/20* *(27)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

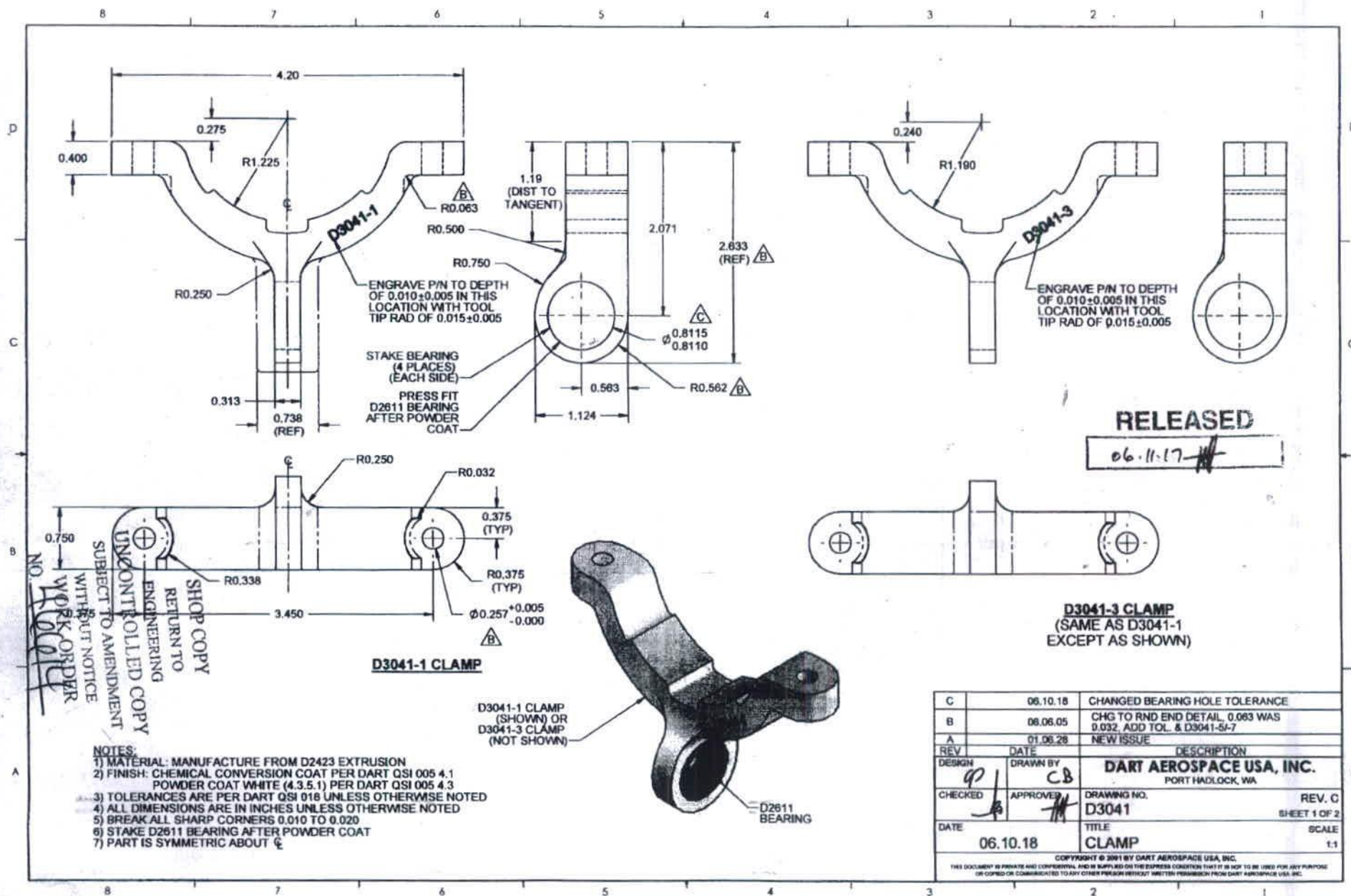
*(27)*  
*D 09/04/20*

Job Completion



*U 09.04.20*





C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5A-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. <b>D3041</b> REV. C
DATE	06.10.18	TITLE <b>CLAMP</b> SHEET 1 OF 2
		SCALE 1:1

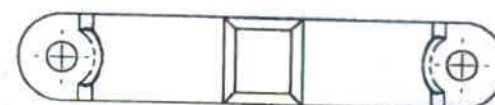
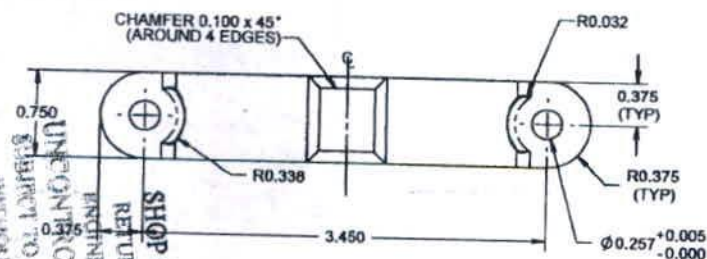
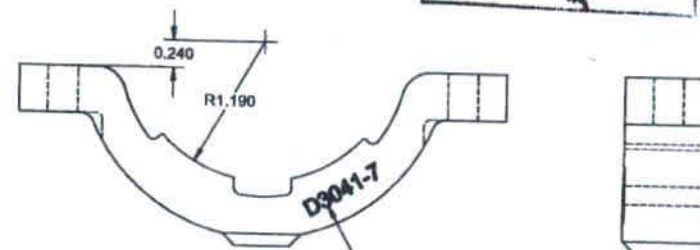
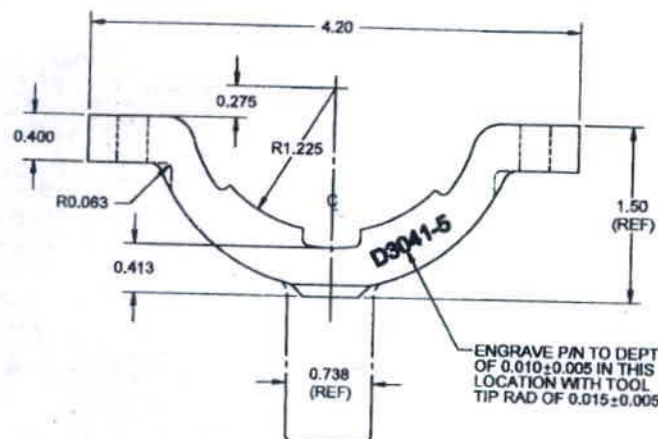
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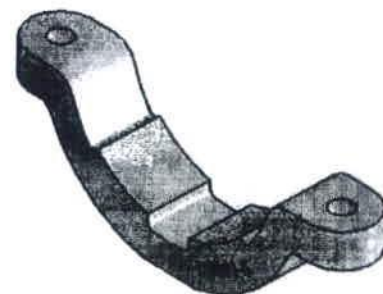
RELEASED

06.11.17



**D3041-7 CLAMP**  
(SAME AS D3041-5  
EXCEPT AS SHOWN)

**D3041-5 CLAMP**



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) PART IS SYMMETRIC ABOUT  $\phi$

DESIGN 90	DRAWN BY CB	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C
DATE 06.10.18	TITLE CLAMP	SHEET 2 OF 2	
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <del>4664</del> 4664
<b>Description:</b> CLAMP		<b>Part Number:</b> D3041-3
<b>Inspection Dwg:</b> D3041 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/- .030	4.201	✓			
0.275	+/- .010	0.272	✓			
R1.225	+/- .010	R1.225	✓			
0.400	+/- .010	0.397	✓			
R0.250	+/- .010	R0.250	✓			
0.313	+/- .010	0.315	✓			
R0.063	+/- .010	R0.063	✓			
1.19	+/- .030	1.19	✓			
1.124	+/- .010	1.128	✓			
0.563	+/- .010	0.563	✓			
R0.562	+/- .010	R0.562	✓			
Ø0.8115-0.8110	N/A	0.8110	✓			
2.071	+/- .010	2.070	✓			
0.750	+/- .010	0.750	✓			
0.375	+/- .010	0.378	✓			
R0.338	+/- .010	R0.338	✓			
3.450	+/- .010	3.449	✓			
Ø0.257	+0.005/-0.000	Ø0.259	✓			
R0.375	+/- .010	R0.375	✓			
0.375	+/- .010	0.376	✓			
R0.032	+/- .010	R0.032	✓			
R0.250	+/- .010	R0.250	✓			

<b>Measured by:</b> H.A	<b>Audited by:</b>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/03/28	<b>Date:</b> 09/03/31	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

